

Work Order ID 117803

May-05-14 8:55:55 AM

117803

Page 1

Item ID: D2739

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 350 I Beam

Start Date: 5/05/14

Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/12/14

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: MLSDate: 14-05-05

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2739

Rev E

100

0.00

100

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

- 1-Cut D2600-5 to length as per Dwg D2739.
2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739
3-Use uni-bit to open holes to finish size as per Dwg D2739.
4-Bevel Fwd end of extrusion and Deburr holes and ends.
5-Deburr

120

0.00

120

Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

DC 14/05/06

14-5-7 J/L/DGL

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Item ID: D2739

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: 350 I Beam

Start Date: 5/05/14

Start Qty: 10.00

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Cust Item ID:

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Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00


130

QC

Memo

0.00

Quality Control

 14-5-8

140

Identify as per dwg & Stock Location: 46

0.00


140

Packaging

Memo

0.00

Packaging

 14-5-8 (10)

150

QC21- Final Inspection - Work Order Release

0.00

150


QC

Memo

0.00

Quality Control

MLG 14-05-08

 14-05-08

Picklist Print

May-05-14 8:55:59 AM

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Work Order ID: 117803

117803

Parent Item: D2739

D2739

Parent Item Name: 350 I Beam

Start Date: 5/05/14

Required Date: 5/12/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev: C02.11.28ReformatKJ
IPP Rev: D 06-03-21 As Per Rev C JLM
IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F
10.11.02 as per revE DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-5-108

Manufactured No

Each 275.0000

10

D2600-5-108

**

Dec 14/05/05

Extrusion 'I Beam' thin

Location

Loc Qty

Loc Code

HALL

23

105417

23

LG

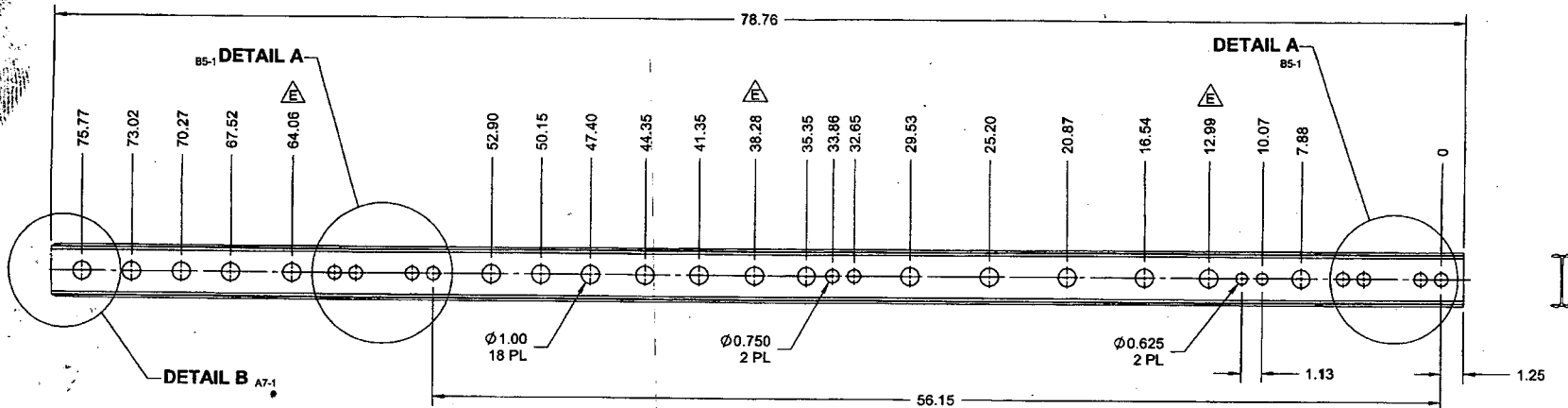
252

112593

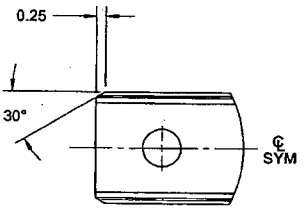
252

10

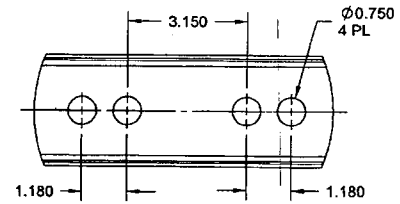
8 7 6 5 4 3 2 1



D2739 WEB



DETAIL B
SCALE 3X C7-1



DETAIL A
SCALE 3X D7-1, D2-1

RELEASED
2010-11-01

117803 MLJ
1405-05

NOTES:

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D2739" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 3.41 lbs

REV.	DESCRIPTION	BY	DATE
E	ADD/MOVE HOLES FOR D4154 WEARPLATE: 38.28 WAS 38.35 (D5-1), 64.06 WAS 64.77 (D7-1), ADD HOLE (D3-1)	CP	10.10.08
D	ADD BEVEL TO FWD END; ADD DETAIL B	CB	07.05.29
C	ADD/MOVE HOLES FOR COMPATIBILITY WITH APICAL FLOATS	PH	06.01.05
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRUISER FLOATS	CP	98.11.18
A	NEW ISSUE	DS	98.04.16
DESIGN	DS	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D2739 TITLE WEB <small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	10.10.08	REV. E SHEET 1 OF 1 SCALE NTS	

8 7 6 5 4 3 2 1

